
QC

Quality Control

Memo

February-14-13 1:59:45 PM Item ID: D2199-23 Accept *N900040100* Setup Start **Revision ID:** Item Name: Strut Details *2* Start Qty: 2.00 **Start Date:** 2/14/13 Cust Item ID: Required Date: 2/25/13 **Req'd Qty:** 2.00 **Customer:** Reference: Run Date: 13-02-19 Tooling: **Process Plan:** Approvals: Date: Stop QC: ____ Date: _____ SPC (Y/N): Date: Operation Sequence ID/ Tool # Plan Set Up/ Tool ID Reject Reject Accept Insp. Run Hours Work Center ID **Description** Qty Qty Code Number Stamp **Draw Nbr Revision Nbr** D2199 Rev E1 100 0.00 NC BRAKE *100* Brake NC 0.00 Memo Brake NC Punch per Dwg D2199 and Spec Control Dwg D2638 110 0.00 Small Fab *110* Small Fab 0.00 Memo Small Fab Deburr 120 QC5- Inspect part completeness to step on W/O *120*

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPI	DATE	QA Closed:	Date:	
Work Orde	or:					DISPOSITION				AGAINST DE		/PROCESS	and second in the second se
Part N	. No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													·
						F	AUI	T CATE	GORY				
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	Н	Turning S			" -	Finish		4	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

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Memo

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Packaging

Packaging

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Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

February-14-13 1:59:45 PM Item ID: D2199-23 Accept *N900040100* Setup Start **Revision ID:** Strut Details Item Name: Start Qty: 2.00 **Start Date:** 2/14/13 **Cust Item ID:** Required Date: 2/25/13 **Req'd Qty:** 2.00 **Customer:** Reference: Run Process Plan: Date: **Tooling:** Approvals: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Work Center ID Description Qty Qty Number Stamp **Run Hours** Code 160 QC21- Final Inspection - Work Order Release 0.00 *160* 0.00 Memo Quality Control

										DQA:	Date	•		
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NCR N	No				Work Order Update		1	Large Fab	Composite	nec/3to	Supplier			
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	Crushed/	Crimped.			Burrs	\perp	Instruct	ions Incomplete/L	Jnclear	Part Lost/M	· L	Wrong Stock Pulled		
	Cuffs				Contamination	<u>_</u>	Mainte	nance		Part Moved				
	Heat Tre	at			Countersink		Mislabe	led		Positioned \		-,		
	Inspection	n Strip in	Tube		Cut Too Short		Misreac	t		Power Loss,	'Surge	Other		
	Ripples i	n Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID:

97098

Parent Item:

D2199-23

Parent Item Name:

Strut Details

Start Date: 2/14/13

Required Date: 2/25/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP: D02.06.10Rem polish & add finishNG/CC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No		,	100	f	418.9640	2.2	4.631579			
304 RD Tube .750 x .049V	V								4. 5 -3	, ,	<u>5</u>	B (30	105/0
				Location		Loc Oty	<u>L</u> c	oc Code			مکن	יכן עי	
				MAT017		418.9640325							
				1093	14	18.666							
				1116	19	6							
				1121	87	8				- · · · · · · · · · · · · · · · · · · ·			
				1204	41	0.008734							
				1211	70	234.89							
				1216	666	15.134							
				1223	12	26.37							
				1224	68	109.895299							
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	•					Rework] :		Skid-tube	Crosstube	_	Water Jet	_	Engineering
Part N	No.					Scrap		ſ	Machining	Small Fab	1	rod. Eng. Coor.	-	Quality
						Use-as-is	_]	Therm	noforming	Finishing	Rec/St	tore/Packaging		Other
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		Cracks				Broken/Damaged	\perp	⊣	on Incomplete	<u> </u>	Part Incor		\vdash	Weld
,		Crushed/	'Crimped			Burrs	\perp	-	ions Incomplete	/Unclear	Part Lost/	_	L	Wrong Stock Pulled
	$oxed{L}$	Cuffs				Contamination	L	Mainte		L	Part Mov			
	L	Heat Tre	at			Countersink	_	Mislabe	led	L	Positione	_	_	1
		Inspectio	n Strip in	Tube		Cut Too Short	1	Misread	1		Power Lo	ss/Surge	1	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

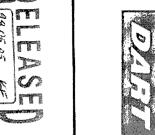
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio



OPTIONAL

98.04.28

ADDED -23 AND ADDED TEMPLATE REDRAWN IN CAD

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-25 PER & SPEC (

CTRL

A565M DWG

ADDED ADDED ADDED NEW ISSUE

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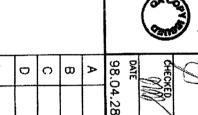
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STRUT DETAILS

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D2199-5	22.64	21.84	0.257	0.316		- 3
D2199-7	14.74	13.94	0.257	0.257	_	1 de
D2199-9	16.52	15.72	0.257	0.257		6 7
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D2199-13	15.96	15.16	0.257	0.257] 📵	Ó
D2199-15	17.57	16.77	0.257	0.257] 📵	9
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√D2199-23	26.18	25.38	0.257	0.316	(E)	
02199-25	19.93	19.13	0.257	0.257		
D2199-27	27.34	24.54	0.257	0.316	3 # 00.10.13 ipoo.10.13	
D2199-29	2.1 11	20.31	0.257	0.257	1) %	

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PUNCH BOTH ENDS PER SPEC CONTROL DRAWING D2638

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER

2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE \$0.750 \times 0.049 WALL

3. FINISH: POWDER COAT WHITE (4:3.5.2) PER DART QSI \$\frac{1}{2}\$ 4:3/E\frac{1}{2}\$